

Date: Monday, 22/12/2008 3:05:45 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PANEL
Job Number : 44240	
Estimate Number : 10906	
P.O. Number :	Part Number : D33303
This Issue : 22/12/2008 S.O. No. :	Drawing Number : D3330 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 37442	Material :
Written By :	Due Date : 20/01/2009 Qty: 3 Um: Each
Checked & Approved By : <u>JD 08.12.23</u>	
Comment : Est. A05.01.13 New issue KJ/JLM Est Rev:B Now on Waterjet 06-09-25 JLM est C 07.05.14 rev C dwg ec Est D 07.12.12 Rev D dwg EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S125	1010-1025 sheet.125
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Comment: Qty.: 0.7130 sf(s)/Unit Total : 2.1389 sf(s)
 1010-1025 sheet.125
 Batch: 109947 HB 9-1-13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3330
 Dwg Rev: D
 Prog Rev: D

HB 9-1-13

(4)

2-Deburr if necessary

HB 9-1-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEHB 9-1-13

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKS 02/01/13 x2

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 488

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/12/2008 3:05:45 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 44240

Part Number: D33303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/15 *AF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-01-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44240
Description: Plate		Part Number: D3330-3
Inspection Dwg: D3330	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.250	+0.005/-0.001	.254	*			
1.02	+/-0.030	1.023	*			
2.500	+/-0.010	2.502	*			
7.00	+/-0.030	7.009	*			
3.26	+/-0.030	3.251	*			
6.05	+/-0.030	6.052	*			
7.11	+/-0.030	7.111	*			
R0.125	+/-0.010	.125	*			
13.98	+/-0.030	13.98	*			
0.852	+/-0.010	.855	*			
1.505	+/-0.010	1.500	*			
4.653	+/-0.010	4.653	*			
1.250	+/-0.010	1.251	*			
0.10	+/-0.030	.098	*			

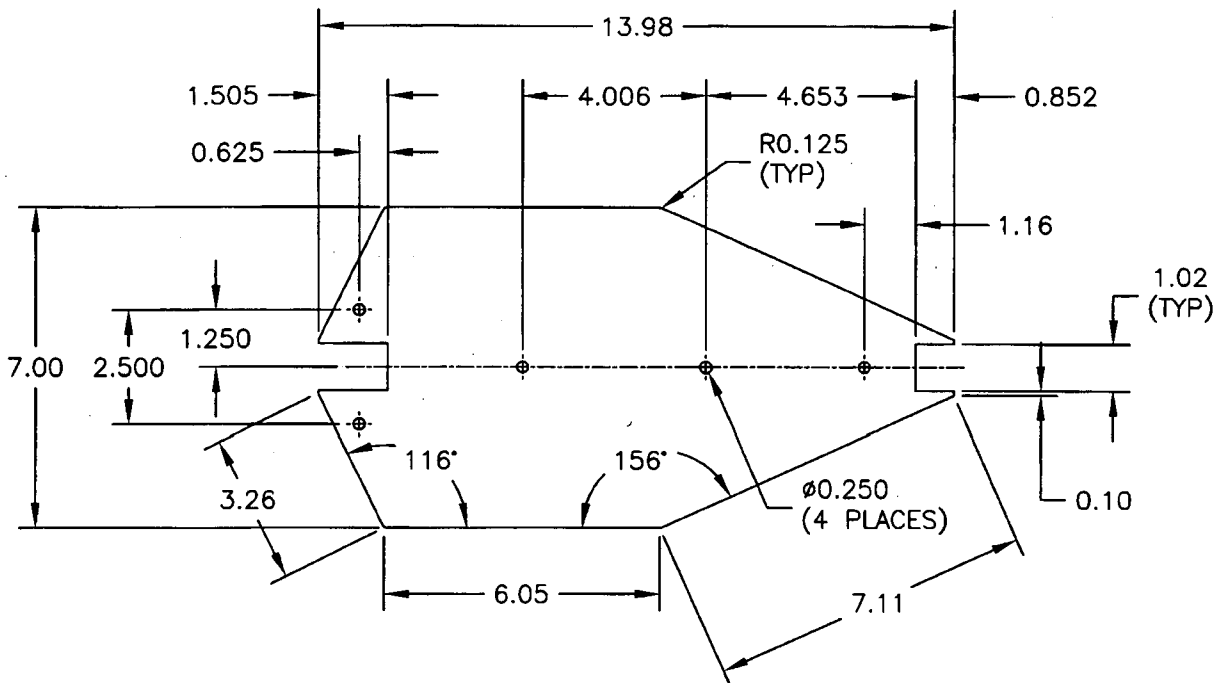
Measured by: LB	Audited by: S	Prototype Approval: N/A
Date: 9-1-13	Date: 09/01/13	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.05.16	New Issue	KJ/JLM	BE

DART

DESIGN 13	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED NA	DRAWING NO. D3330	REV. D SHEET 4 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
07.12.07

**D3330-3 PLATE**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44240

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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